

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020480**Date Inspected:** 11-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng /Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 002 located on BK009A5-001. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 560 located on BK009A7-001. Welder is identified as 040533. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 002 located on BK009A3-001. Welder is identified as 040302. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

In Process Inspection FCAW

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This QA Inspector observed the following work in progress: FCAW welding of weld joint 069 located on BK011A7-001. Welder is identified as 205649. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08131

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK004A2-033-001, 003, 004, 005, 006, 007, 009, 010, 011, 012

BK004A3-033-019, 020, 043, 044, 033, 058, 059, 021, 022, 045, 046, 030, 031, 056, 057, 005, 009, 032

BK004A4-033-006, 007, 032, 033, 058, 059, 021, 022, 047, 048, 073, 074, 004, 005, 030, 031, 056, 057, 019, 020, 045, 046, 071, 072

BK004A5-033-112, 115, 118, 121, 122, 125, 128, 131, 014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045, 064, 065, 084, 085, 110, 111, 113, 134, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133, 004, 007

BK004A6-033-072, 073

BK004A8-033-072, 073

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08134

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK004C2-024-013, 021, 002, 008, 014, 015, 017, 019, 020

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08136

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK004-033 Step 10

### Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08131.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK004A2-033-001, 003, 004, 005, 006, 007, 009, 010, 011, 012

BK004A3-033-019, 020, 043, 044, 033, 058, 059, 021, 022, 045, 046, 030, 031, 056, 057, 005, 009, 032

BK004A4-033-006, 007, 032, 033, 058, 059, 021, 022, 047, 048, 073, 074, 004, 005, 030, 031, 056, 057, 019, 020,

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045, 046, 071, 072

BK004A5-033-112, 115, 118, 121, 122, 125, 128, 131, 014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045, 064, 065, 084, 085, 110, 111, 113, 134, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133, 004, 007

BK004A6-033-072, 073

BK004A8-033-072, 073

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08134.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK004C2-024-013, 021, 002, 008, 014, 015, 017, 019, 020

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Leavitt, Scott

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer